

Work Order ID 76368

76368

Page 1

November-10-11 11:51:26 AM

Item ID: D205-634-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 10/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 28/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: M L J

Date: 11/11/10

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2580-041

Rev.E

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

CHG005

N/A

110

0.00

110

BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

①

②

SAD 12-01-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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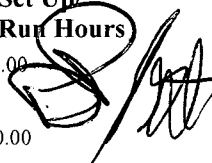

Page 2

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Item ID: D205-634-041 Accept ***N900040100*** Setup Start ***NS1***
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 Start Date: 10/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* Skidtubes	Memo 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004	0.00 		12-1-39					
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 				1	0	FE12-01-31	

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Run Start *NR1*

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Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00

140

Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R Aluminum Rod

11/19/12

BE 12-01-31

2-Grind welds on step as per Dwg D2580

SAD 12-02-01

3-Weld spacers as per dwg D2580

N/A DP 12-1-31

3- ~~***~~ Insert D4202-1 spacer, swage as per QSI002 and trim/ grind
flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2
x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension.

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Debur

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

△*

Handwritten signature and date 12-1-31

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Page 4

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC10- Inspect visual per QSI004- ground welds	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Pressure Wash per QSI005 4.3	0.00							
170									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.								

W/O:		WORK ORDER CHANGES					
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180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

180

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:00
3200 F
12:30

IX J M-L 12/02/02

190

QC3- Inspect Part Finish

0.00

190

QC

Quality Control

Memo

0.00

1 6 M 12/02/02

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Page 6

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00

200

HandFinish

Hand Finishing

Memo

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 M1119508Sikaflex expire date: 12/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with

Sikaflex. Clean excess adhesive

A/R Sikaflex-291 M1119508Sikaflex expire date: 12/08

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: M11701751 4 11 12/02/02

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Page 7

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 *210* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024	0.00 0.00							
220 *220* Packaging Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: _____	0.00 0.00							
230 *230* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

8/2/06

PPP 77647

06/12/08

12/2/8

MF
12-02-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

November-10-11 11:51:30 AM

Page 1

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 10/11/2011

Required Date: 28/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
KJ IPP Rev P 10.02.19
per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1		Manufactured	No			140	Each	492.0000	20	20			

D4202-1

Spacer

Location	Loc Qty	Loc Code
LG002	492	
66929	106	
67129	196	
67308	1	
67430	140	
72639	49	

**

12-1-31

D2580-1

Manufactured No

110

Each

5.0000

1

1

D2580-1

205 Skidtube bent detail

**

12-01-30

Location	Loc Qty	Loc Code
LG	3	
72965	1	
75282	2	
ST046	2	
75284	2	

378701

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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November-10-11 11:51:30 AM

Work Order ID: 76368

76368

Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 10/11/2011

Required Date: 28/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2576-3 Manufactured No

140

Each

112.0000

1

1

D2576-3

Step (maching detail)

**

[Handwritten signature]

BE 12-01-31

Location

Loc Qty

Loc Code

LG

112

66156

12

70883

50

74136

50

D2855 Manufactured No

200

Each

10.0000

1

1

D2855

Cap

**

B75074 (x1) M 12/02/02

Location

Loc Qty

Loc Code

FP007

10

65519

2

65569

8

AN3-5A Purchased No

200

Each

924.0000

2

2

AN3-5A

Bolt

**

M 12/02/02

Location

Loc Qty

Loc Code

ST350

924

115371

46

117423

378

118626

300

119355

200

AN960JD10L NAS1149D0332J Purchased No

200

Each

0.0000

2

2

***AN960JD10I ***

Washer

**

M119042 (x2) M 12/02/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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November-10-11 11:51:30 AM

Page 3

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D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 10/11/2011

Required Date: 28/11/2011

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

Purchased

No

200

Each

1,999.000

50

50

AI S7-1032-130

Insert

ALS4-1032-130

**

M119084 (x50) M12/02/02

Location

Loc Qty

Loc Code

ST281

113

117717

27

118966

86

ST282

1886

119530

1886

AN3C4A

Purchased

No

200

Each

2,173.000

50

50

AN3C4A

BOLT

**

M119749 (x50) M12/02/02

Location

Loc Qty

Loc Code

ST350

2173

117313

2

117688

5

117872

22

118112

16

118451

2

118706

152

118838

974

119328

1000

AN960C10L

NAS1149C0332

Purchased

No

200

Each

0.0000

50

50

***AN960C10I ***

washer

**

M119736 (x50) M12/02/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

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D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 10/11/2011

Required Date: 28/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3566-13	Manufactured	No	200	Each	30.0000	1	1
D3566-13						**	B76947 (x1) M 12/02/02
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	29	
73322	29	
FP014	1	
68341	1	

D3566-5	Manufactured	No	200	Each	30.0000	1	1
D3566-5						**	B77945 (x1) M 12/02/02
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	30	
74387	8	
75069	22	

D3566-1	Manufactured	No	200	Each	33.0000	2	2
D3566-1						**	B76942 (x2) M 12/02/02
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	31	
73303	5	
74518	26	
FP015	2	
68924	2	

D3564-11	Manufactured	No	200	Each	5.0000	1	1
D3564-11						**	B77614 (x1) M 12/02/02
Wearshoe							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP019	5	
73146	5	

W/O:		WORK ORDER CHANGES					
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Page 5

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Parent Item Name: Replacement Skidtube

Start Date: 10/11/2011

Required Date: 28/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-13

Manufactured No

200

Each

17.0000

1

1

D3564-13

Wearshoe

**

B35045 (x1) MU 12/02/02

Location

Loc Qty

Loc Code

FP001

16

73323

16

FP017

1

71594

1

D3564-9

Manufactured No

200

Each

16.0000

1

1

D3564-9

Wearshoe

**

B377613 (x1) MU 12/02/02

Location

Loc Qty

Loc Code

FP

11

73345

11

FP019

5

67590

4

69943

1

D3564-5

Manufactured No

200

Each

22.0000

1

1

D3564-5

Wearshoe

**

B376269 (x1) MU 12/02/02

Location

Loc Qty

Loc Code

FG

2

34806

2

FP001

12

74543

12

FP19

8

73330

8

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Page 6

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D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 10/11/2011

Required Date: 28/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2594-3 Manufactured No

200 Each 736.0000 16 16

D2594-3

O-Ring, 205 Skidtube

**

u 12/02/02

Location

Loc Qty

Loc Code

FP004

198

73490

198

FP-A

538

65518

41

66952

199

73490

298

x16

D2594-1 Manufactured No

200 Each 352.0000 16 16

D2594-1

Plug, 205 Skidtube

**

u 12/02/02

Location

Loc Qty

Loc Code

FP

352

73401

352

B78590

x8

X B76075

x8

W/O:		WORK ORDER CHANGES					
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LIST OF MATERIALS					
ITEM	QTY -041	QTY -045	QTY -047	PART NUMBER	DESCRIPTION
1	X			D2580-041	SKIDTUBE ASSEMBLY
2		X		D2580-045	SKIDTUBE ASSEMBLY
3			X	D2580-047	SKIDTUBE ASSEMBLY
4	1	1	1	D2500-1-190	EXTRUSION
5			16	D2570	BUSHING
6	1	1	1	D2576-3	STEP
7	20	24	25	D2579	SPACER
8	16	16	8	D2594-1	PLUG
9	16	16	8	D2594-3	O-RING
10	1	1	1	D2596	205 WEB
11	1	1	1	D2855	AFT CAP
12	1	1		D3564-5	WEARSHOE
13	1	1		D3564-9	WEARSHOE
14	1	1		D3564-11	WEARSHOE
15	1	1		D3564-13	WEARSHOE
16	2	2		D3566-1	GASKET
17	1	1		D3566-5	GASKET
18	1	1		D3566-13	GASKET
19			1	D4406-041	WEARPLATE ASSEMBLY
20			1	D4406-043	WEARPLATE ASSEMBLY
21	50	50		ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
22	50	50		AN3C4A	BOLT
23	2	2	2	AN3-5A	BOLT
24			8	AN4-45A	BOLT
25	50	50		NAS1149C0332R	WASHER (AN960C10L)
26	2	2	2	NAS1149D0332J	WASHER (AN960JD10L)
27			8	MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB.
POWDER COAT ASSEMBLY (-041/-047) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT ASSEMBLY (-045) GREEN SANDEX (REF 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 34.5 lbs
D2580-045 = 34.5 lbs
D2580-047 = 37.7 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/-291.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

RELEASED
2011-08-29

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WORK IN PROGRESS
NO. 76368 M.C.J.

E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS: DT8217 & DT8937 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/ 9183	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	98.08.26
B	AS MANUFACTURED	DS	96.12.02
A	NEW ISSUE	DS	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	#		
DRAWN	RF		
CHECKED	MP		
MFG. APPR.	DS		
APPROVED	MP		
DE APPR.	#		
DATE	11.06.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. E
D2580 SHEET 1 OF 8
TITLE SCALE
205 SKIDTUBE ASSEMBLY NTS

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

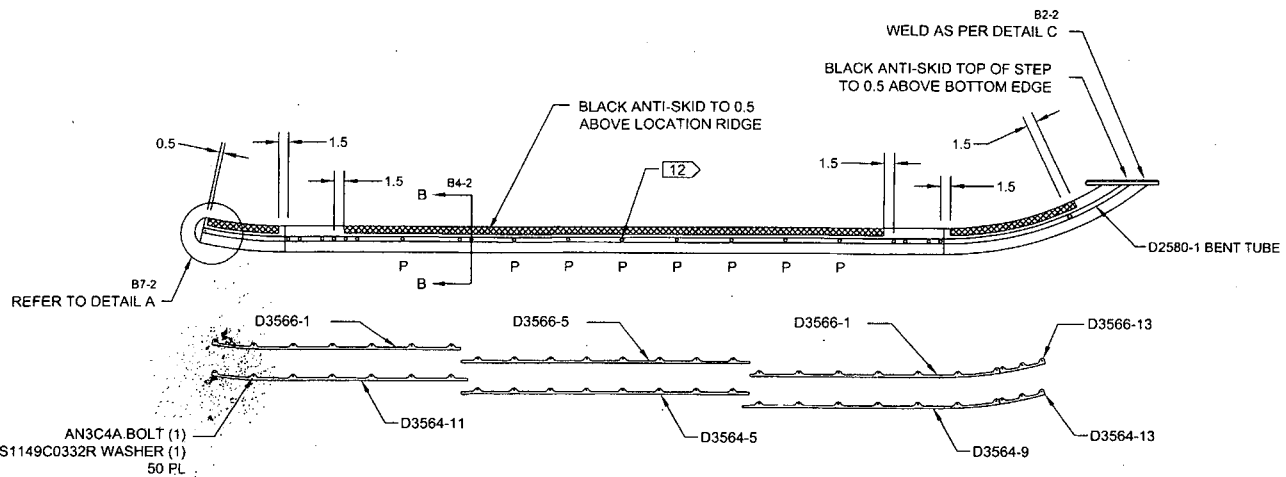
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

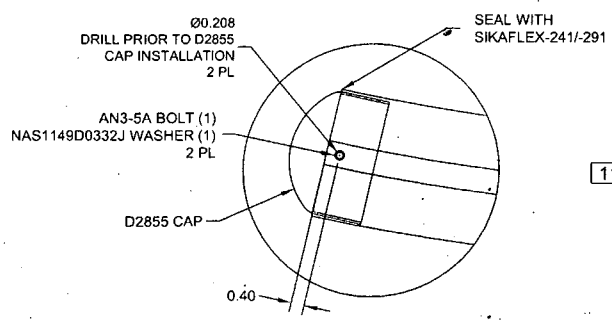
NOTE: Date & initial all entries

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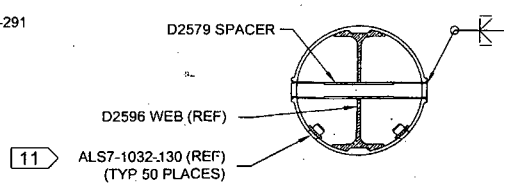


D2580-041 ASSEMBLY DETAIL

DETAIL A
SCALE 5X

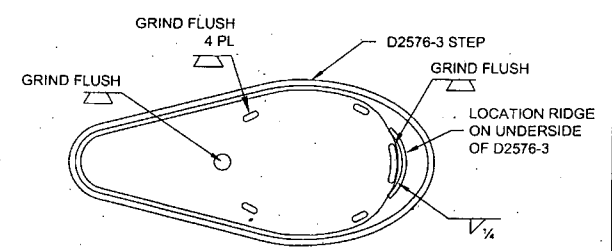


SECTION B-B
SCALE 5X



- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D2579 SPACER (20 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

DETAIL C
SCALE 5X



DESIGN	RF	DART AEROSPACE LTD	
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CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D2580	SHEET 2 OF 8
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DE APPR.	RF	205 SKIDTUBE ASSEMBLY	NTS
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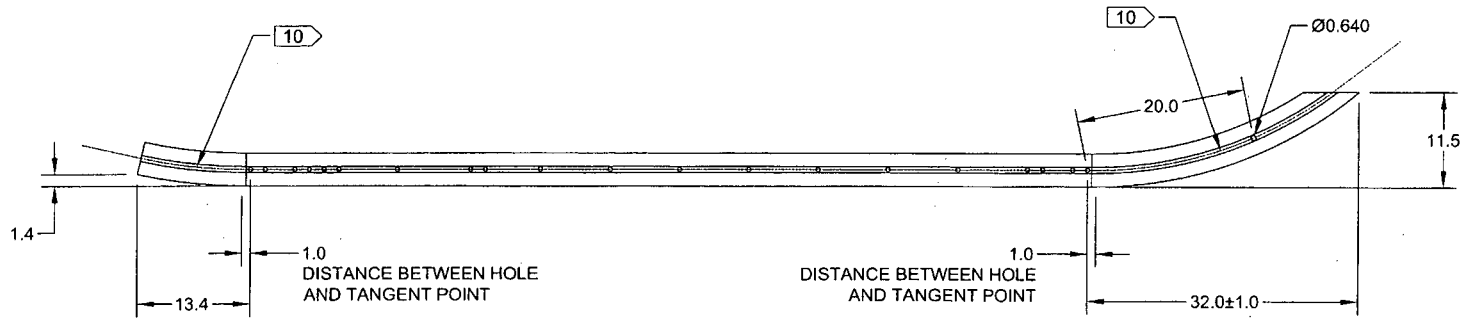
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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2011-08-28

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MFG. APPR.	10	D2580	SHEET 3 OF 8
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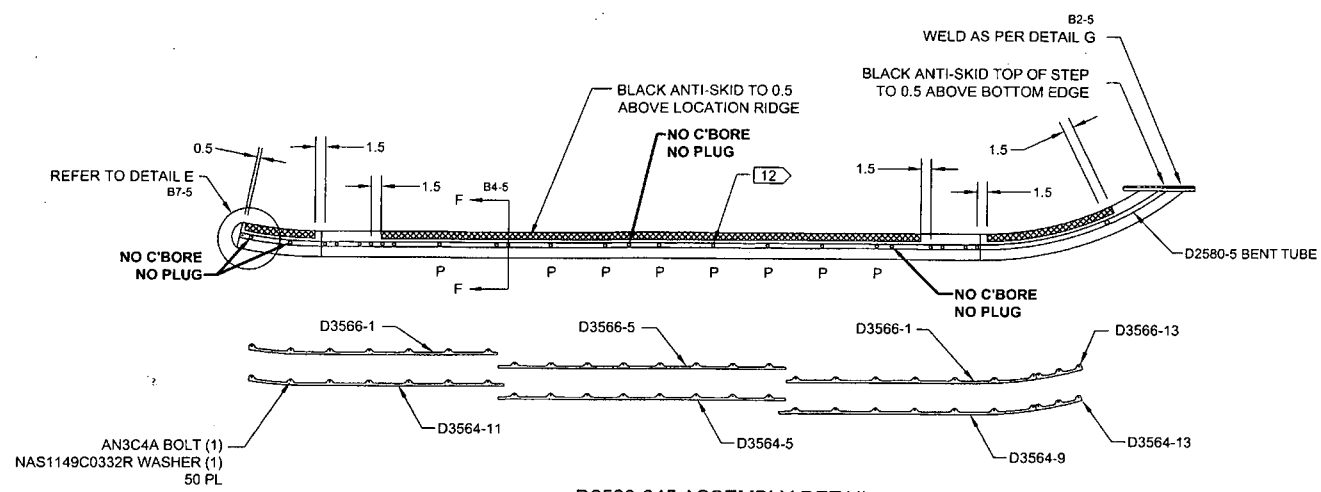
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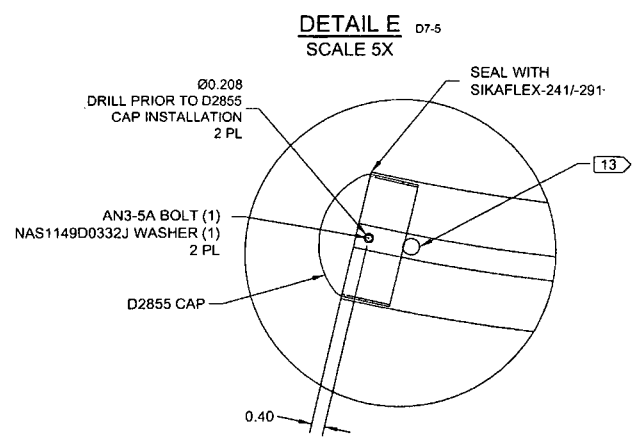
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

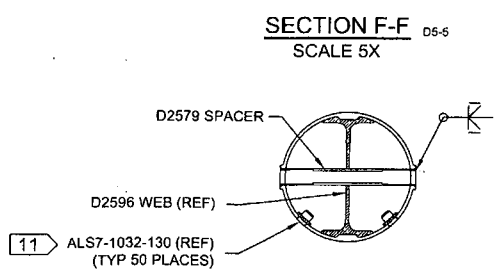
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D2580-045 ASSEMBLY DETAIL

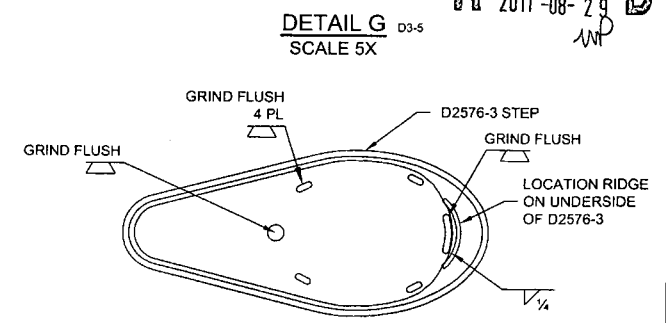


DETAIL E D7-5 SCALE 5X



SECTION F-F D5-5 SCALE 5X

- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D2579 SPACER (24 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP



DETAIL G D3-5 SCALE 5X

DESIGN	#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2



2011-08-29
IN

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MFG. APPR.	1	D2580	SHEET 5 OF 5
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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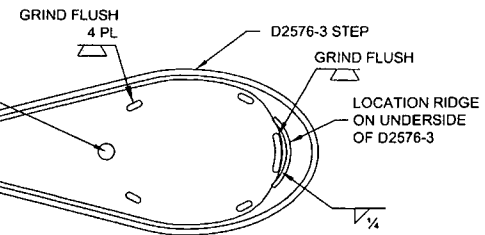
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$\triangle E$



DETAIL J D3-7
SCALE 5X



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MFG. APPR.	<i>N</i>	D2580	SHEET 6 OF 6
APPROVED	<i>AP</i>	TITLE	SCALE
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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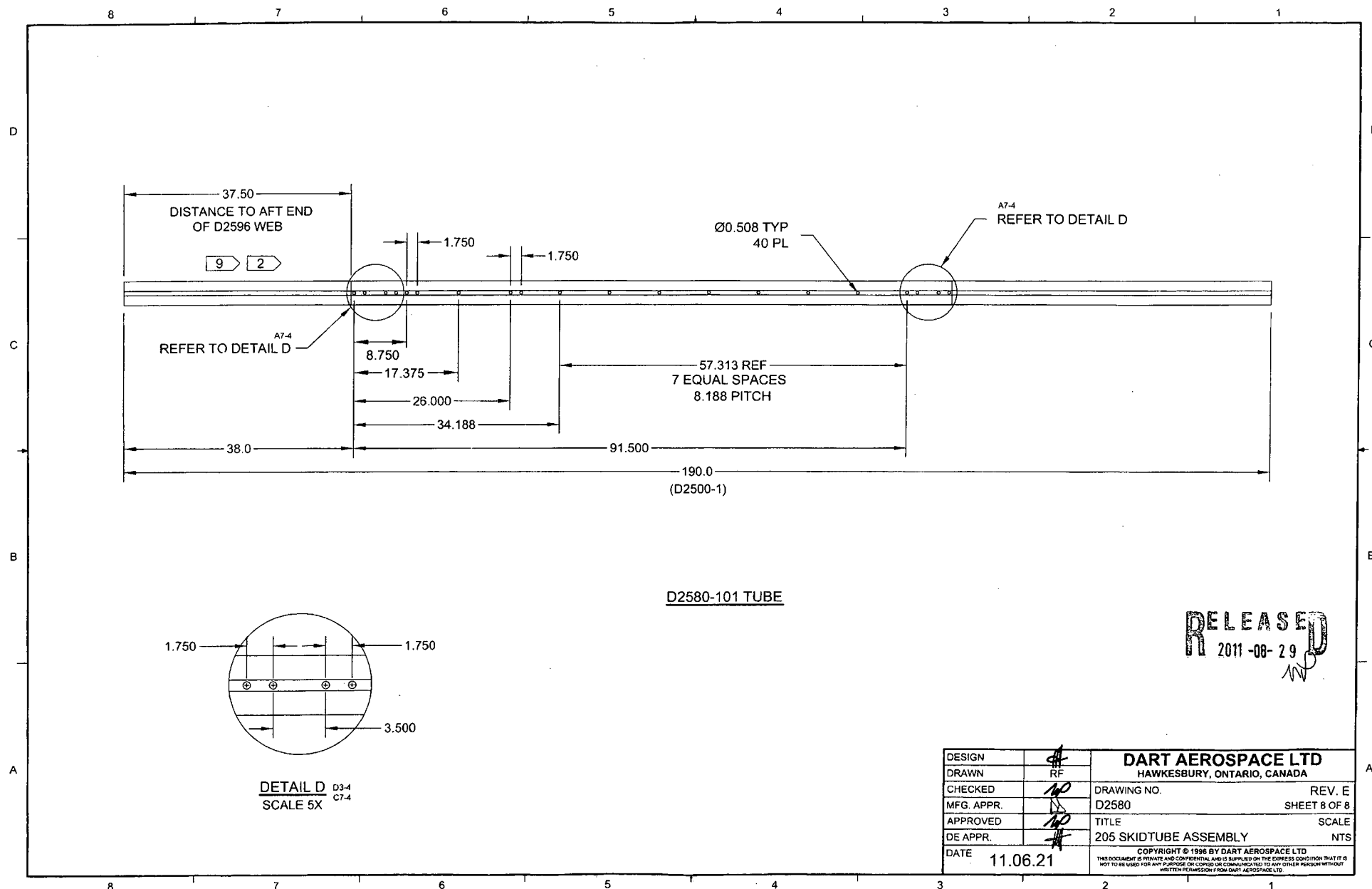
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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